

Date: Thursday, 20/11/2008 3:35:17 PM  
User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET		
Job Number	: 43621			Part Number	: D3209041		
Estimate Number	: 11147			Drawing Number	: D3209 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 20/11/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 21/12/2008		
Previous Run	: 38190			Qty:	<i>10</i>		
Written By	:			Um:	Each		
Checked & Approved By	<u>JL 08.11.21</u>						
Comment	: Est A04.06.09 New issue KJ/RF						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.50 x 1.25	
		Comment: Qty.: 0.1838 f(s)/Unit Total : 0.7350 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B1.500x01.250) Identify for D3209-1 Batch: <u>M107461</u>	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1 Deburr and Tumble	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UJ

08-11-26

x10

7.0 POWDER COATING

POWDER COATING



M109648



10X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

START TIME: 2 = 10

2 = 10

m-f 08/11/26

OVEN TEMPERATURE: 320°

0

FINISH TIME: 2 = 40

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/11/26

10

9.0 D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

1 D3209-3 Bushing

B320907 (P)

B35633 (3)

Press fit bushing into the bracket as per Dwg D3209

08/11/27 (O)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S6811157 (X)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

SL 08/11/27 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43621

Part Number: D3209041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/28 Jy

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	11302
Description: Bracket	Part Number:	D3209-1
Inspection Dwg: D3209	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

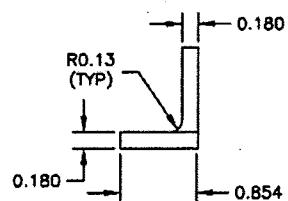
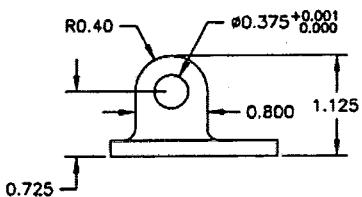
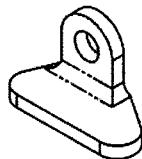
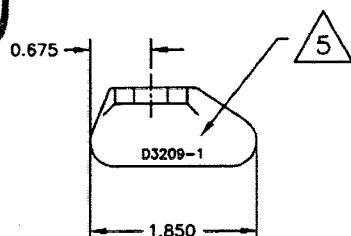
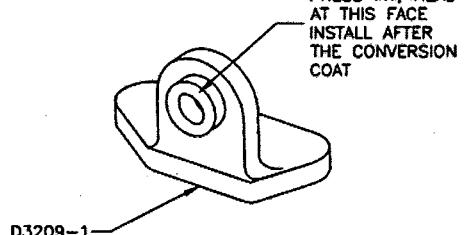
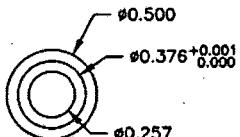
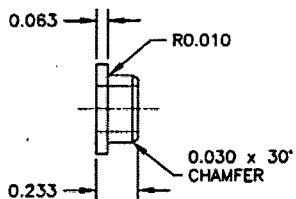
## X First Article Prototype

Measured by:	DP	Audited by:	JL	Prototype Approval:	N/A
Date:	08/11/25	Date:	08/11/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	SJL

**DART**

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE BRACKET	SCALE 1:2	
A	04.01.27	NEW ISSUE	

**RELEASED**04.04.05 *H***D3209-1 BRACKET****D3209-3 BUSHING**

SCALE 1:2

**D3209-041 ASSEMBLY****D3209-1 BRACKET; D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) UNCONTROLLED COPY
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 SUBJECT TO AMENDMENT
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE
- 7) ALL DIMENSIONS ARE INCHES WORK ORDER  
NO. 43621

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 43621